Work Orde Thursday, Augus					*105	5868°	k						Page 1	
Revision ID:	D4148-041 FWD X-TUB	E LUG ASS'Y			Accept	*N9	റററ	4∩ ⁻	100) *	Setup Star Stop	14.7	1* 2*	
Required Date:	8/22/2013 8/22/2013 rework per e	Start Qty: 4.00 Req'd Qty: 4.00 cm 13-624		*4* *4*		Cust I Custo	tem ID: mer:							}
Approvals:	Process Pla	ın: MY.	Date:	13-820	Tooling:		Date:			I	Run Star	*NR	1*	
	QC:		Date:		SPC (Y/N):	· · <u></u>	Date:	-			Stop	*NR	22*	
Sequence ID/ Work Center II)	Operation Description	· · · · · · · · · · · · · · · · · · ·	 - · " ,	Set Up/ Run Hours	Tool	ID To	ool#	Plan Code	Accept Qty	Reject Qty	-	nsp. Stamp	· •
Draw Nbr	Rev	ision Nbr		·									·	-
D4148	E													
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140 Mill Conv		Memo			0.00					5	N	/	/w/ [3/01/2	7
Conventional Millin	g Machine	pull from s 2 x b1004 1 x b1009 1 x b1021 1 x b9334	52 98 57	041 x 4 and rewo	ork per new drawing									
		·(1												
150		QC5- Inspect part com	pleteness to s	step on W/O	0.00									
150					721	•				5				
QC Quality Control		Мето			12 8	\sim								

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				DQA:	Date	:
CR: '	es /	No	WORK ORDER NON-CONFORMANCE / UPDA	ATE		 -

											QA Closed:	Date	2:
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N	ا ۱۰۰					Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update		nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	1	ief Eng	Desc	ription	Date	Verification	QC Inspector
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		Centre No	ot Concer	ntric to (o/s	BOM/Route		Hardwa			Over/Under	├	Temperature/Cure
	-	Cracks			_	Broken/Damaged		,	ion Incomplete		Part Incorred	}_	Weld
	_	Crushed/	Crimped		<u> </u>	Burrs	<u> </u>		ions Incomplete/	'Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	匚	Cuffs			<u> </u>	Contamination	\vdash	Mainte			Part Moved		
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		Inspectio		Tube	<u> </u>	Cut Too Short	-	Misread	i i		Power Loss/	Surge	Other
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1	\	Wave/Tw	ist in Tub/	oe e		Folio		Outside	Dimensions				

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QC

Quality Control

Thursday, August 22, 2013 4:02:34 PM Item ID: D4148-041 Accept Setup Start *N900040100* Revision ID: Item Name: FWD X-TUBE LUG ASS'Y Start Date: 8/22/2013 Start Oty: 4.00 Cust Item ID: Required Date: 8/22/2013 Req'd Qty: 4.00 Customer: Reference: rework per ecn 13-624 Run Date: Approvals: Process Plan: Tooling: Date: Stop QC: Date: Date: SPC (Y/N): Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. Work Center ID Description **Run Hours** Code Qty Qty Number Stamp Identify as per dwg & Stock Location: 57455 160 0.00 5x - 4,10 13-08-27 *160* Packaging 0.00 Memo Packaging 170 QC21- Final Inspection - Work Order Release 0.00 *170* MLJ 13-08-28

0.00

Memo

Q113-04-28

										DQA:	Date:	
NCR: Yes	/ No				WORK ORDER NON-	CONFO	RN	MANCE / UP		QA Closed:	Date:	
Work Order:			-		DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS	
Part No.					Rework Scrap Use-as-is Work Order Update	The	N erm	Skid-tube Machining oforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Initia	1	Ac	tion	Sign &		
Cause	Date	Step	Qty	C	or Non-conformance	Chief E	ng	Desc	ription	Date	Verification	QC Inspector_
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Grain Ovalized Pressure/Forced Bending Bend Centre Not Concentric to O/S BOM/Route Over/Under tolerance Temperature/Cure Hardware Weld Cracks Broken/Damaged Inspection Incomplete Part Incorrect Part Lost/Missing Wrong Stock Pulled Crushed/Crimped Burrs Instructions Incomplete/Unclear Part Moved Cuffs Contamination Maintenance Positioned Wrong Countersink Mislabeled Heat Treat Misread Power Loss/Surge Other Inspection Strip in Tube Cut Too Short Drill Holes Ripples in Bend Offset Out of Calibration Torque Waves in Extrusion Drawing Turning Sequence Finish Out of Sequence Folio Outside Dimensions Wave/Twist in Tube

General

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Landing Gear

Work Order ID:

105868

Parent Item:

D4148-041

Parent Item Name:

FWD X-TUBE LUG ASS'Y

Start Date: 8/22/2013

Required Date: 8/22/2013

Page 1

Start Oty: 4.00

Required Qty: 4.00

Comments:

IPP Rev;A 10.06.24 new issue DD verf:EC

IPP Rev:B 10.07.22 as per revB DD verf:JLM

IPP Rev:C 10.10.29 as per revC

DD verf:EC

IPP REV:D 11.03.02 AS PER DWG REV.D DD VERF;EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4148-041		Manufactured	No				Each	0.0000		4		 -	_

FWD X-TUBE LUG ASS'Y

(x 10001087 (x 10210 (x 10310

Mer 8,26

											DQA	: Da	ite:	
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						1		Г	<u></u>				ie.	
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	_					Rework	٦		Skid-tube	Crosstube	7	Water Jet		Engineering
Part	No.					Scrap]		Machining	Small Fab	Pro	od. Eng. Coor.		Quality
				· -		Use-as-is]	Thern	noforming	Finishing	Rec/Sto	ore/Packaging	\blacksquare	Other
NCR	No.					Work Order Update			Large Fab	Composite		Supplier		
Root				<u> </u>	Descr	ription of work order update	\top	<u>I</u> Initial	Act	tion	Sign &			
Cause		Date	Step	Qty		or Non-conformance	Cł	nief Eng	Desc	ription	Date	Verificatio	n	QC Inspector
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		Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Incorre	ect	\square	Weld
		Crushed/	Crimped			Burrs		Instruct	tions Incomplete/	Unclear	Part Lost/M	lissing		Wrong Stock Pulled

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish Folio Part Moved

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

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Thursday, August 22, 2013 3:57:21 PM

Item ID	Warehouse ID	Lot Number	Last Trans Date	Lot Qty Shelf	Life Dt	Type Code	Comments
Item Name	Location 1D	-	· · · · · ·	- - ·	Lot Code		
04148-041 FWD X-TUBE LUG ASS'Y	Main Warehouse ST	100462	8/22/2013	1.0000	QC21		
	Main Warehouse ST	100998	8/22/2013	1.0000	QC21		
	Main Warehouse ST	102167	8/22/2013	1.0000	QC21		
	Main Warchouse ST	93346	8/22/2013	1.0000	QC21		

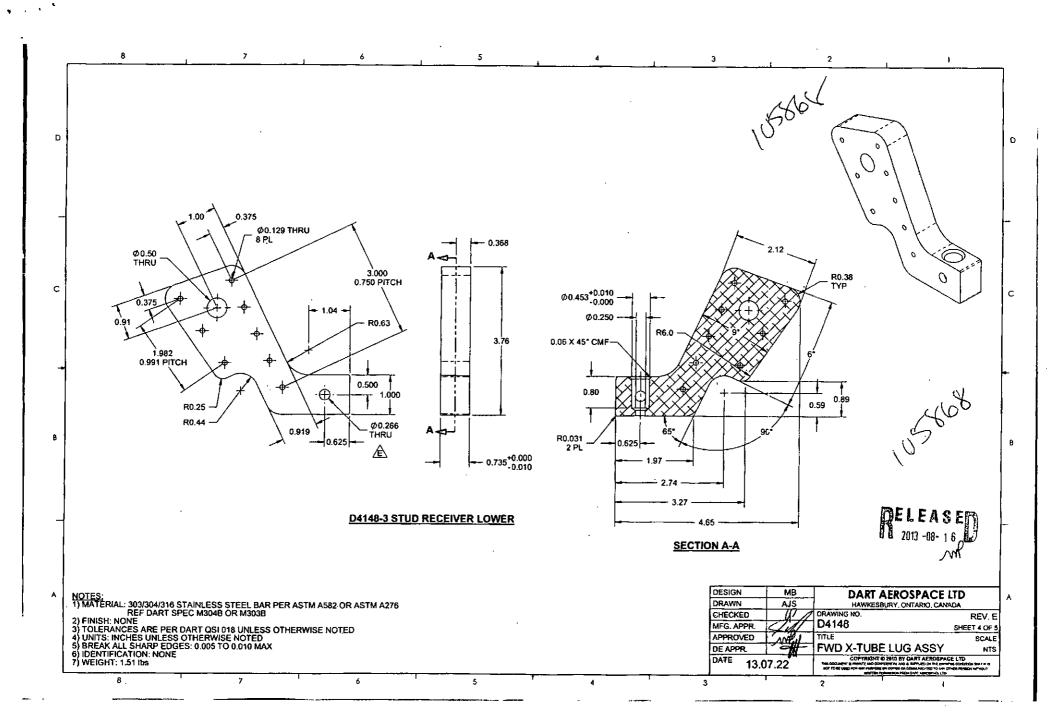
QA:	Date:	
)QA:	Date:	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

NCK. 1									QA Closed:	Date	e:
Work Orde	r:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	" "
Part N					Rework Scrap		Skid-tube Machining	Crosstube Small Fab	-1	Water Jet d. Eng. Coor.	Engineering Quality Other
NCR N	o				Use-as-is Work Order Update	Ine	rmoforming Large Fab	Finishing Composite	, Rec/stor	re/Packaging Supplier	- Other
Root					ption of work order update	Initial		tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Er	g Desc	ription	Date	Verification	QC Inspector
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						AULT CAT	EGORY			<u> </u>	
Landin F	g Gear				General	<u></u>		_	٦	Г	7
	Bending	_		<u> </u>	Bend	Grain		⊢	Ovalized	}	Pressure/Forced
	Centre No	ot Concei	ntric to C	^{D/S} -	BOM/Route	Hardy			Over/Under	_	Temperature/Cure
Ļ	Cracks			-	Broken/Damaged		ction incomplete	,, , <u> </u>	Part Incorred	 	Weld
}	Crushed/	Crimped		-	Burrs	-	ctions Incomplete	'Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
1	Cuffs			<u> </u>	Contamination	\vdash	tenance	<u> </u>	Part Moved		
1	Heat Trea			\vdash	Countersink	Misla		. _	Positioned V		-,
ļ	Inspectio		Tube	<u> </u>	Cut Too Short	Misre		L	Power Loss/	Surge	Other
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<u> </u>	Torque W			·	Drawing	-	f Calibration				
ļ	Turning S	Sequence			Finish	Out o	f Sequence				
1	Wave/Tw	vist in Tub	oe.	ı	1Folio	I lOutsi	de Dimensions				

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										DQA:	Date:	
NCR: Ye	es / N	o			WORK ORDER NON-	COI	NFORI	MANCE / UI	PDATE	QA Closed	Date:	
Vork Order	·:			·	DISPOSITION		·		AGAINST I	DEPARTMENT	/PROCESS	
Part No	Part No				Rework Scrap Use-as-is Work Order Update	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite				Water Jet od. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
Root				Desc	cription of work order update	Ti	nitial	A	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Des	cription	Date	Verification	QC Inspector
oc/Data quip/Tooling perator laterial etup ther rocess upplier raining					•							
			_			FAUL	T CATE	GORY				
Landin	Landing Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion			General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread Offset Out of Calibration			Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V	ct issing Wrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled	
<u> </u>		g Sequence		t	Finish		Out of	Sequence				

Outside Dimensions

Wave/Twist in Tube

Folio

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DART AEROSPACE LTD	Work Order: 105818
Description: FMD x tale for same	Part Number: // 4/48 - 0 4/
Description: FWD x - tube hung arang	rait (diliber. // 4/ 4% - 8 4/
Inspection Dwg: Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of inspection	Comments
80,216	+ 0,006	0.269	/		1411-04	vern
0.500	+ 0,010	0.501	/		111	
0,216 0,500 0,625	= 0.010	0,269	/		111	111
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Measured by:	KILP	Audited by:	27	Preliminary Approval:	
Date:	13/08/27	Date:	13857	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

	· •	